



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

WJH
D4297-3

Job Sheet 168464



Part No: D4297-3

Job Qty: ~~6~~ ea
7

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/14/17

Job Tracking No:

Due Date: 12/5/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 12-07-25 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		12/4/17	0.00	0.00	Start Up Container		<i>DC</i>
120	Waterjet	6 pcs		12/4/17	0.00	1.69	Waterjet1		<i>DC</i>
130	CNC Vertical Machining	6 pcs		12/5/17	0.00	11.95	HAAS 1		<i>SL</i>
140	QC	6 pcs		12/5/17	0.00	0.00	QC2		<i>SL</i>
150	QC	6 pcs		12/5/17	0.00	0.00	QC8		
151	Packaging	6 pcs		12/5/17	0.00	0.00	Packaging3	<i>SLV 38A</i>	<i>EB</i>
190	QC21-SA	6 Ea		12/5/17	0.00	0.00	QC21		<i>DEC 12 2017</i>

Part Op 120 - Cut Blank as per D2432 File (SAME BLANK AS D2432)

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA127 and Dwg DWG

REV: _____ FOLIO REV: _____ 3-Debur

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MUHMWB10	22	1,190	0	0

Part Specifications

Specifications could not be found.

Plex 11/14/17 4:41 PM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

QA Ck

Work

Date

PART NO:
Revision:
Operation:
Change No:

Start up Operation

D4297-3

Bearpaw



S015514



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

AGAINST DEPARTMENT/PROCESS			
Skid-tube	Cross tube	Water Jet	Engineering
Machining	Small Fab	Prod. Eng. Coord.	Quality
Thermoforming	Finishing	Rec/Store/Packaging	Other
Large Fab	Composite	Supplier	

QTY Effective :

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

FAULT CATEGORY

☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong
☐ Set-up	☐ Folio/Program	☐ Outside Dimensions
☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect
☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Contamination	☐ Out of Sequence	☐ Part Moved
☐ Countersink	☐ Off-set	☐ Drawing
☐ Cut Too Short	☐ Mislabeled	☐ Finish
☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence

OTHER :

Intern.

Tribal Knowledge

LOA

Substation

Past Expiry Date

Misidentified

Rushing

Product Improvement

Process Improvement

Manufacturing Process

Past Due

Heat Treat

Wave/Twist in Tube

Marks/Chatter

DART AEROSPACE LTD		Work Order:	168464
Description: Bearpaw		Part Number:	D4297-3
Inspection Dwg: D4297 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.060 x 45	✓		vern	mm L-05
B	0.25 x 45°	+/-0.030	0.250 x 45	✓		"	
C	R0.250	+/-0.030	0.250	✓		R6	
D	0.63	+/-0.030	0.623	✓		vern	mm L-05
E	0.38	+0.030/-0.010	0.405	✓		"	
F	0.95	+0.030/-0.030	0.963	✓		"	
G	19.000	+/-0.030	19.0	✓		tape	
H	Ø0.260	+0.005/-0.001	0.260	✓		vern	mm L-05
I	Ø0.93	+/-0.030	0.930	✓		"	
J	0.30	+0.030/-0.000	0.317	✓		"	
K	23.750	+/-0.030	23.750	✓		tape	
L	2.00	+/-0.030	2.018	✓		vern	mm L-05
M	0.47	+/-0.030	0.475	✓		"	
N							
O							
P							
Q							
R							
S							
T							
U							

Measured by:	mark	Audited by:		Preliminary Approval:	
Date:	17/12/07	Date:		Date:	

Rev	Date	Change	Revised by	Approved
A	15.02.03	New Issue	KJ	
B	15.02.09	Dimensions revised	KJ	

